

Date: Wednesday, 26/11/2008 12:45:47 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACKER PLATE
Job Number : 43744	
Estimate Number : 11802	
P.O. Number :	Part Number : D25281
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D2528 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C1
Previous Run : 26373	Material :
Written By :	Due Date : 10/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.11.23</u>	
Comment : Est:C 00.06.26 Removed P/O for powder coat EC Est Rev:D 08-07-23 now made on water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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**Comment:** Qty.: 0.0318 sf(s)/Unit Total : 0.3182 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 107272 B 8-12-17

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2528

Dwg Rev: C1Prog Rev: C1B 8-12-17(18)

2-Deburr if necessary

08/12/18(18)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-12-17**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK08/12/18(18)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/12/18(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: BACKER PLATE

Job Number: 43744

Part Number: D25281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109996



(18x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 OF
8:30

MF 08/12/19

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/12/19 (18)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5A 35

MF 08/12/19 (18)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22

Job Completion



MF 08-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460 ; 1.00 WAS 1.000	

RELEASED
98.12.11 KE

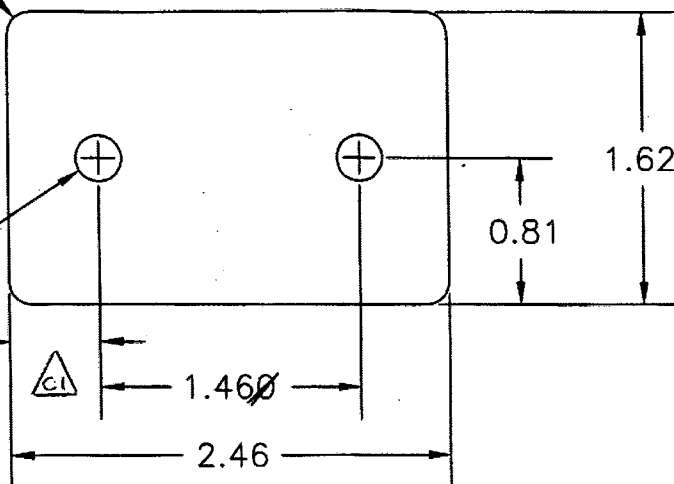
R0.13 (TYP)

UNDER REVIEW

01.12.03

Ø0.257 (TYP)

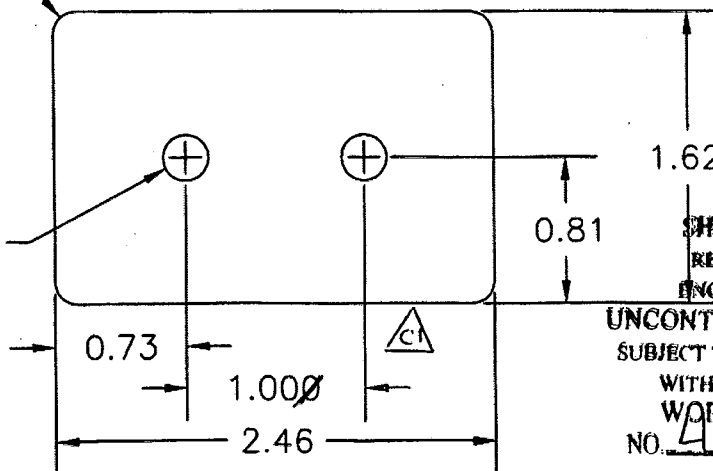
0.50



D2528-1

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43241

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order: 43744
Description: BACKER PLATE	Part Number: D2528-1
Inspection Dwg: D2528-1, Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x | Prototype

[illegible]

Measured by:	IB	Audited by:	J	Prototype Approval:	A
Date:	8-12-17	Date:	08/12/18	Date:	1/18

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	